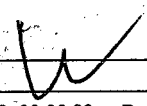
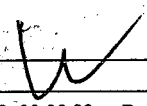


Friday, 08/06/2007 9:24:35 AM  
Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L/L 1/L3 SCUFF PLATE, AFT RH
Job Number	: 32767	Part Number	: D206555009
Estimate Number	: 12273	Drawing Number	: D206-555 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 08/06/2007 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: NA
First Issue	: N/A	Due Date	: 30/06/2007
Previous Run	: 32767	Qty:	10 Um: Each
Written By	: 		
Checked & Approved By	: 		
Comment	: Est C 99.06.29 Returned to Electro Polish DM Est Rev:D Now on Waterjet 07-06-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-009

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.8348 sf(s)/Unit Total: 8.3475 sf(s)

304/316 .020" Sheet

BATCH: M103508

M 07 06 12

(10)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C

M 07 06 12

(10)

2-Deburr if necessary

SAN

07/06/26

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 07 06 12

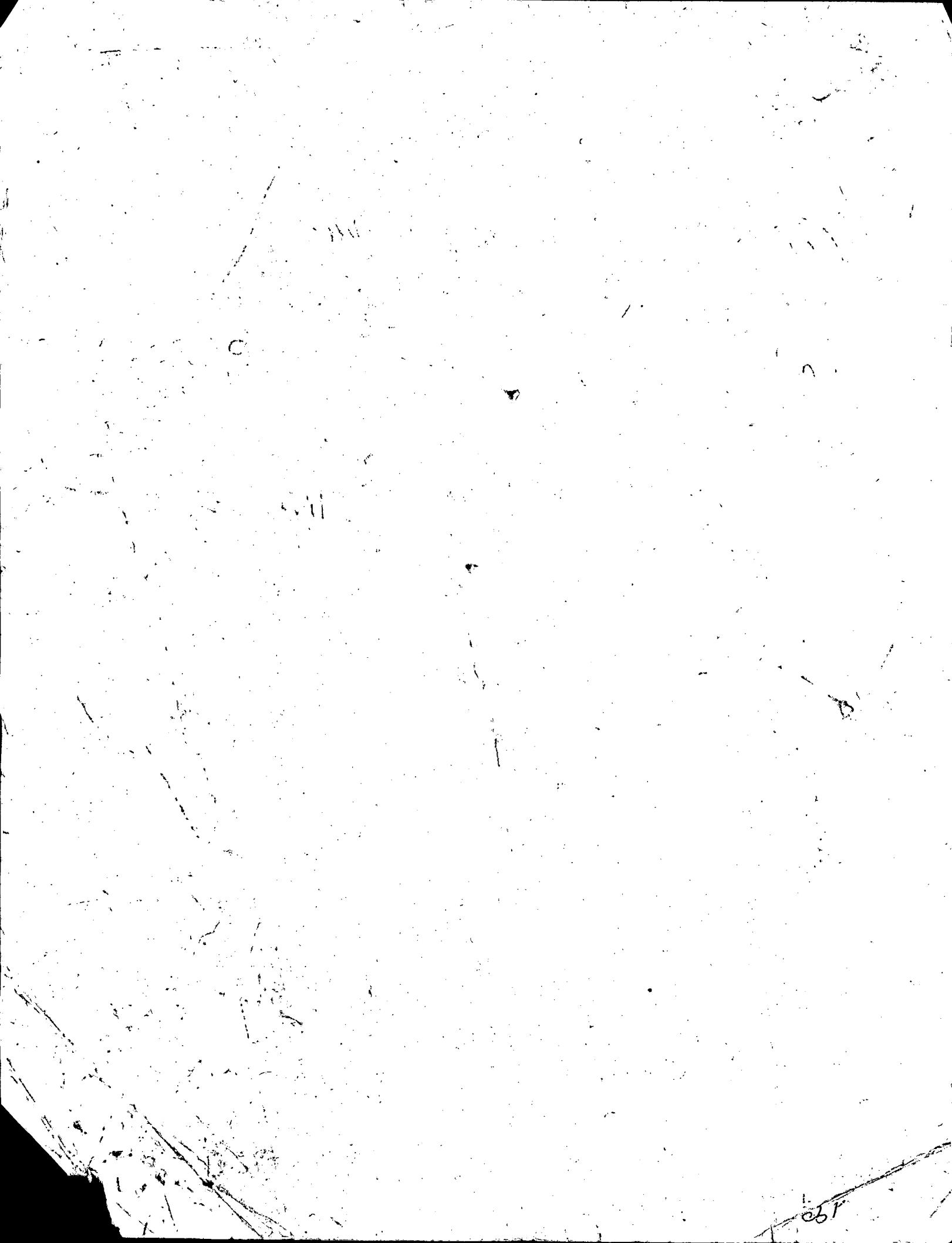
(10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

2706-13 (10)



Date: Friday, 08/06/2007 9:24:35 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Job Number: 32767

Part Number: D206555009

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove Tabs

Form parts on hydraulic press as per Dwg. D206-555 using DT 8324-9

Finish form on bench forming Jig DT 8325-9

SB 07/08/10

Polish #  
07-08-10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/23

FF 07-10-23

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 4886 C907/10/24

Possible supplier: TOF Technologies

15/11/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/11/04

15/11/04

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/11/05

9

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/11/05

15/11/04

Date: Friday, 08/06/2007 9:24:35 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Job Number: 32767

Part Number: D206555009

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

DD 08/11/05

Job Completion



U 07.11.05

Date: Wednesday, 6/6/2007 1:44:52 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L/L 1/L3 SCUFF PLATE, AFT RH
Job Number	: 32767		
Estimate Number	: 12273		
P.O. Number	:	Part Number	: D206555009
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: D206-555 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 26229	Material	:
Written By	:	Due Date	: 6/30/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est C 99.06.29 Returned to Electro Polish DM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL  
 Type Labels as per PPP D206-555-009

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Email or ship DXF file to vendor  
 Laser cut part as per DXF file  
 Material release note required

*M304/5256A  
 .85K*

*W. Johnston*

3.0	D206555009F	Scuff Plate Aft RH 206L
-----	-------------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 SCUFF PLATE FLAT

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/19	5	Split into	JS	07/10/19	9		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:44:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Job Number: 32767

Part Number: D206555009

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove Tabs

Form parts on hydraulic press as per Dwg. D206-555 using DT 8324-9

Finish form on bench forming Jig DT 8325-9

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV:20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: \_\_\_\_\_

Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 6/6/2007 1:44:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Job Number: 32767

Part Number: D206555009

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

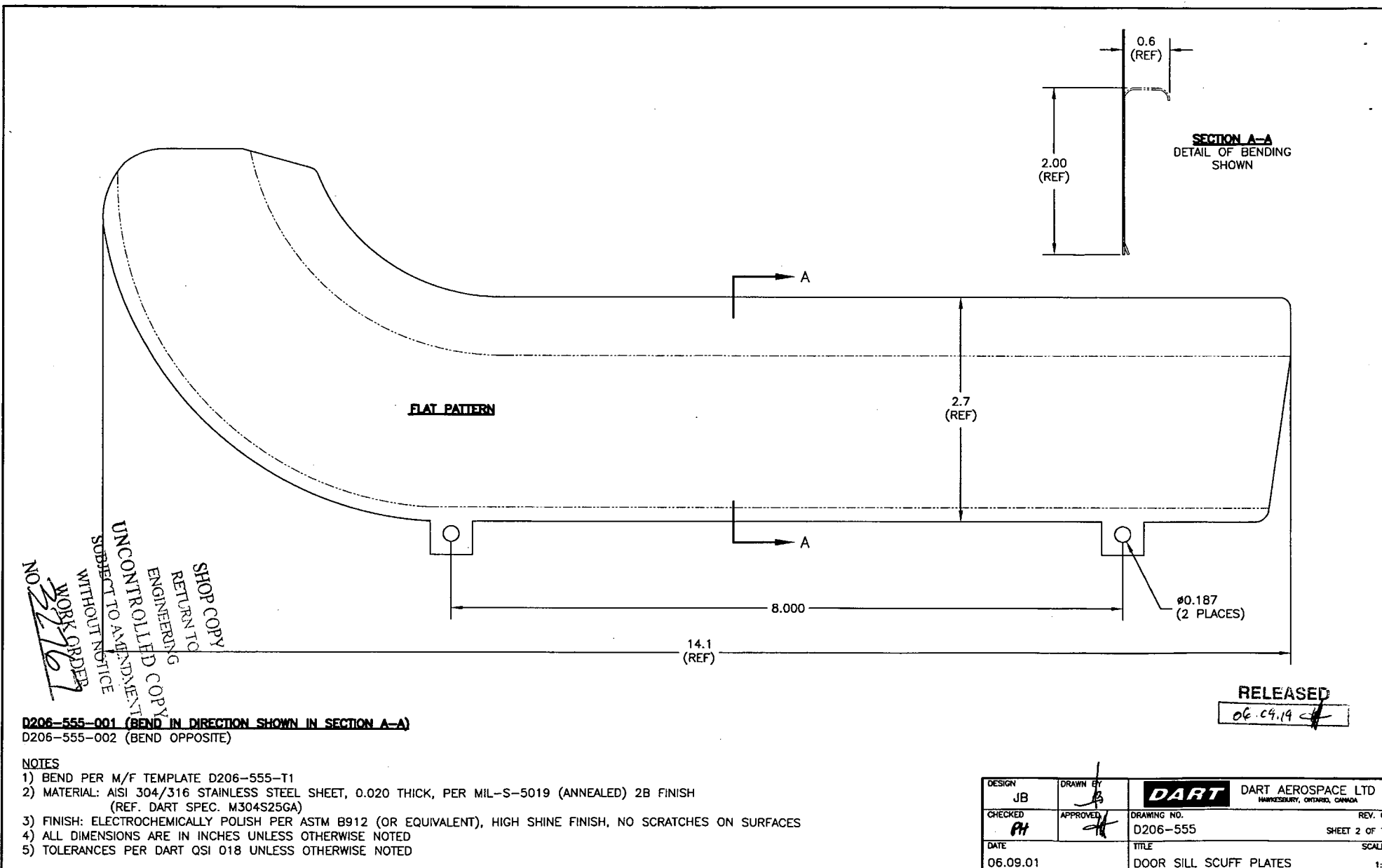
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

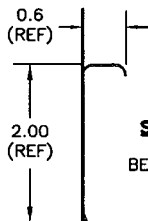
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY  
**RELEASED** RETURN TO  
06.09.19 *[Signature]* ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32767

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**SECTION C-C**  
DETAIL OF  
BENDING SHOWN

**DETAIL B**  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

**FLAT PATTERN**

8.000

19.0  
(REF)

8.000

Ø0.187  
(3 PLACES)

2.7  
(REF)

16.000 (REF)

NO. 32767  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING

**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**  
**D206-555-004 (BEND OPPOSITE)**

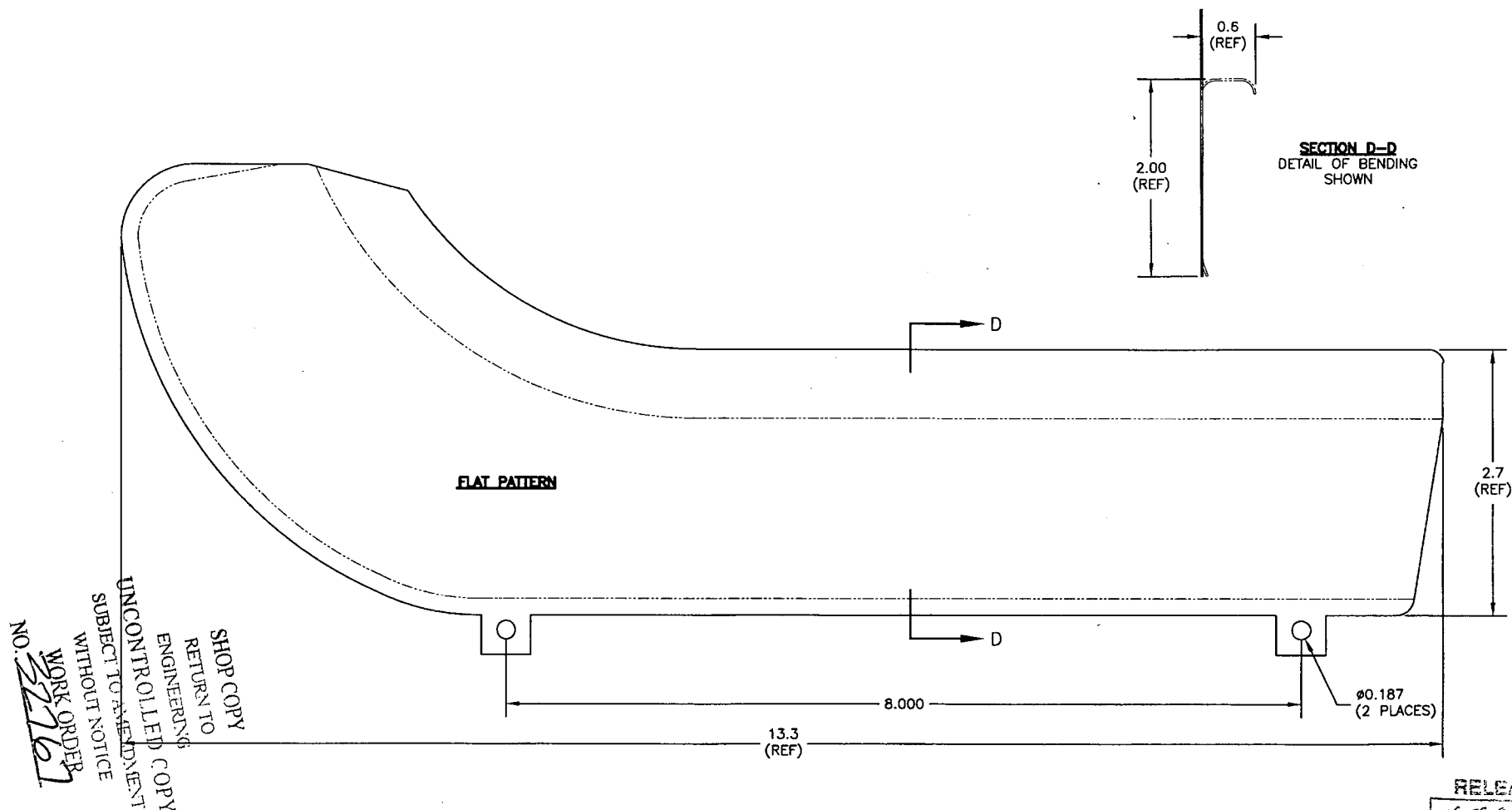
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**

06.09.19-#




DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED BY PH	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3

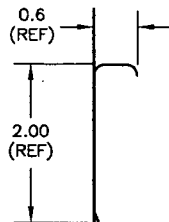


D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)  
 D206-555-006 (BEND OPPOSITE)

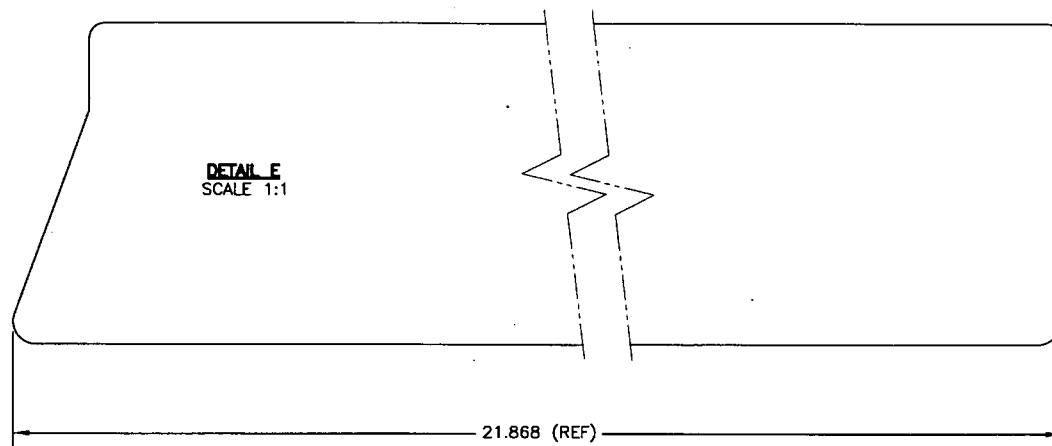
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY 	 DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. C
CHECKED 	APPROVED 		SHEET 4 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES		SCALE 1:1

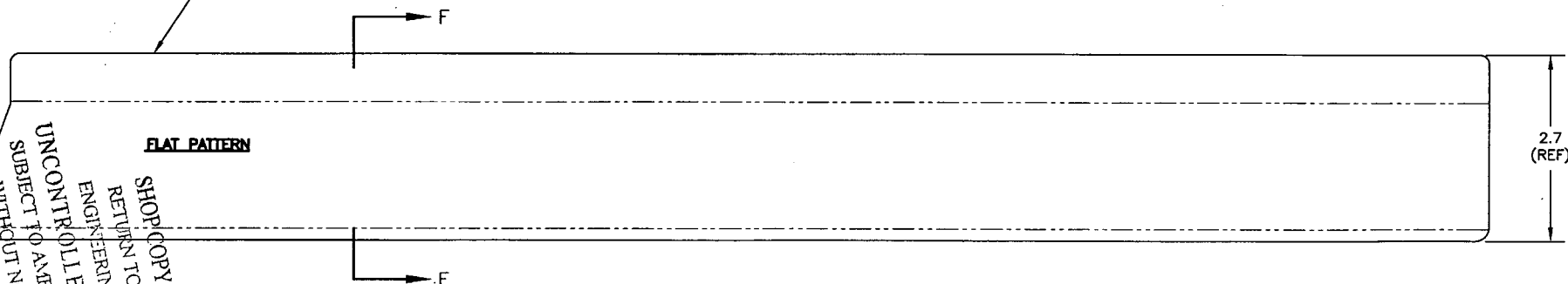


**SECTION F-F**  
DETAIL OF  
BENDING SHOWN



**DETAIL E**  
SCALE 1:1

REFER TO DETAIL E  
FOR 1:1 SCALE



**FLAT PATTERN**

2.7  
(REF)

NO. 20767  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP/COPY  
WITHOUT NOTICE

RELEASED

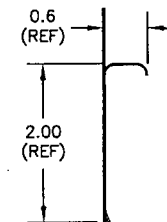
06.09.19

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

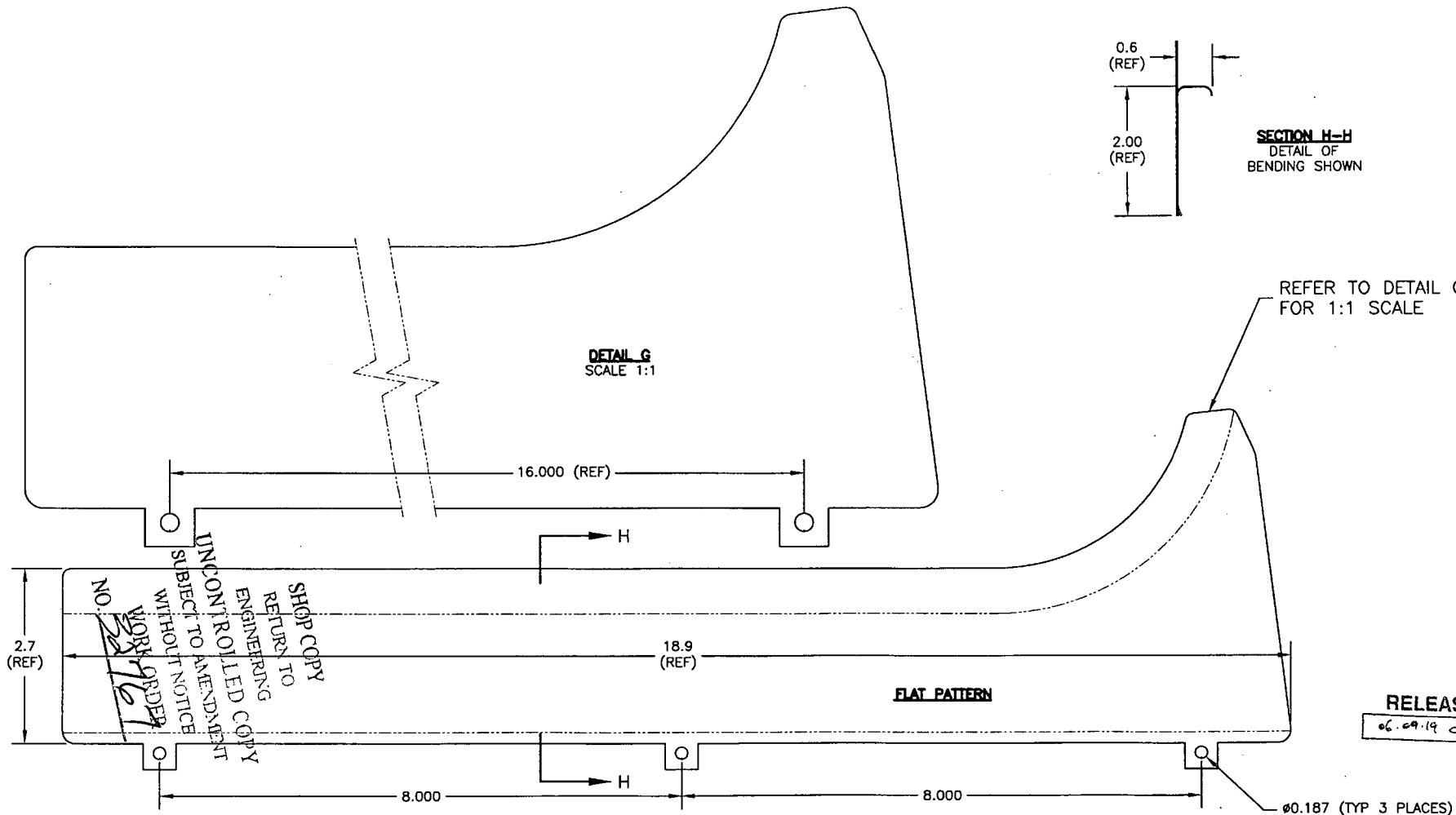
DESIGN JB	DRAWN BY [Signature]	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	REV. C SHEET 5 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



**SECTION H-H**  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE

**DETAIL G**  
SCALE 1:1



**FLAT PATTERN**

**RELEASED**

06.09.19

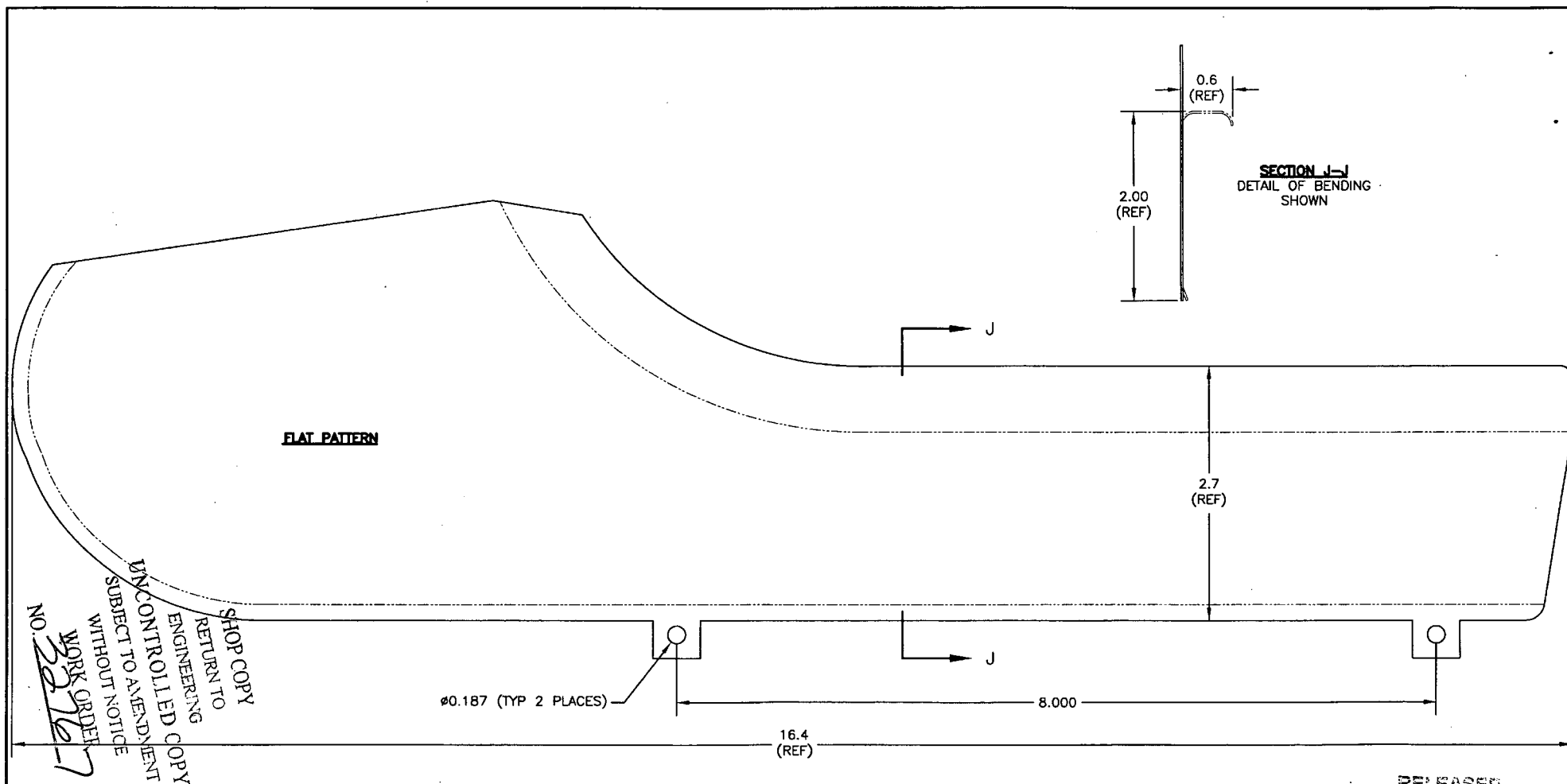
**D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	





D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

#### NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.01

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED JB	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1

DART AEROSPACE LTD		Work Order: 32767
Description: 206 L/L1/L3 Scuff Plate, Aff RH		Part Number: D206-SSS-009
Inspection Dwg: D206-SSS Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.181$	$\pm 0.005-0.001$	0.188	✓		VWV	
B 2.7	$\pm 0.100$	2.7	✓		VWV	
C 18.9	$\pm 0.100$	18.875	✓		M-T	
D 8.000	$\pm 0.010$	8.000	✓		M-T	
E 8.000	$\pm 0.010$	8.000	✓		M-T	
F 16.000	$\pm 0.010$	16.000	✓		M-T	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by: [Signature]	Prototype Approval: N/A
Date: 07-06-12	Date: 07-06-13	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



# Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 1, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

**C121120**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
132319		NO. DE COM./P.O.# 4886	
	8	D206-555-002 CUST. REF.:B32855	ELECTROPOLISH PER ASTM B912 REV.02
	8	D206-555-007 CUST. REF.:B32909	
	9	D206-555-009 ✓ CUST. REF.:B32767	

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

*Signé pour et au nom de TQF Technologies Inc.*  
*Signed for and on behalf of TQF Technologies Inc.*




Raj Thakoordeen

Total Quality Finishing